

Work Order ID 79468

79468

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January-26-12 1:05:33 PM

Item ID: D2174-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web, 205
 Start Date: 26/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2174	Rev E

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg D2174-0412- Identify as D2174-041								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: _____ FINISH TIME: _____								

m 121134
3200F
3:45
4:15

5x *Ø* *12/01/12*

(x)

5x *m-f* *12/04/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				5	0	12-4-18	
140 *140* Small Fab Small Fab	Small Fab Memo Install nuts & bolts loosely as per Dwg D2274	0.00 0.00				5x	0	12/04/19	
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				5		12/04/19	

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location <u>234B</u>	0.00				(5)		12/4/19	
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/4/19

12-04-19

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79468

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Parent Item: D2174-041

D2174-041

Parent Item Name: Web, 205

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: D04.06.10Reformat; Changed Step 2KJ/JLM
IPP Rev:E As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2174-1 *D2174-1* Web		Manufactured	No			100	Each	1.0000	1	4			
<div> <div>Location</div> <div>GA</div> <div>50234</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2175-1 *D2175-1* Angle LH		Manufactured	No			100	Each	0.0000	1	4			
D2175-2 *D2175-2* Angle RH		Manufactured	No			100	Each	0.0000	1	4			
MS21042L08 *MS21042L 08* Nut		Purchased	No			100	Each	494.0000	4	16			
<div> <div>Location</div> <div>ST300</div> <div>120071</div> <div>120142</div> <div>120308</div> </div> <div> <div>Loc Qty</div> <div>494</div> <div>94</div> <div>300</div> <div>100</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
AN526C832R14 *AN526C832R14* Screw		Purchased	No			140	Each	426.0000	4	16			
<div> <div>Location</div> <div>ST348</div> <div>104916</div> </div> <div> <div>Loc Qty</div> <div>426</div> <div>426</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

B 79469 (4x)

B 79470 (5x)

B 79471 (5x)

M120833 (20x)

12/04/17
 12/04/17
 12/04/17
 12/04/19
 12/04/19
 20

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Parent Item: D2174-041

D2174-041

Parent Item Name: Web, 205

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN960JD8 NAS1149DN832 Purchased No

140 Each 0.0000 4 16

AN960JD8

Washer

MS20470AD4-6

Purchased No

140 Each 3,283.000 19 76

MS20470AD4-6

Rivet, Universal Head

**

**

Location

Loc Qty

Loc Code

ST319

3283

117395

28

118927

404

119109

363

119546

1000

120142

1488

Handwritten signatures and dates:
 12/04/19
 12/04/17
 95

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

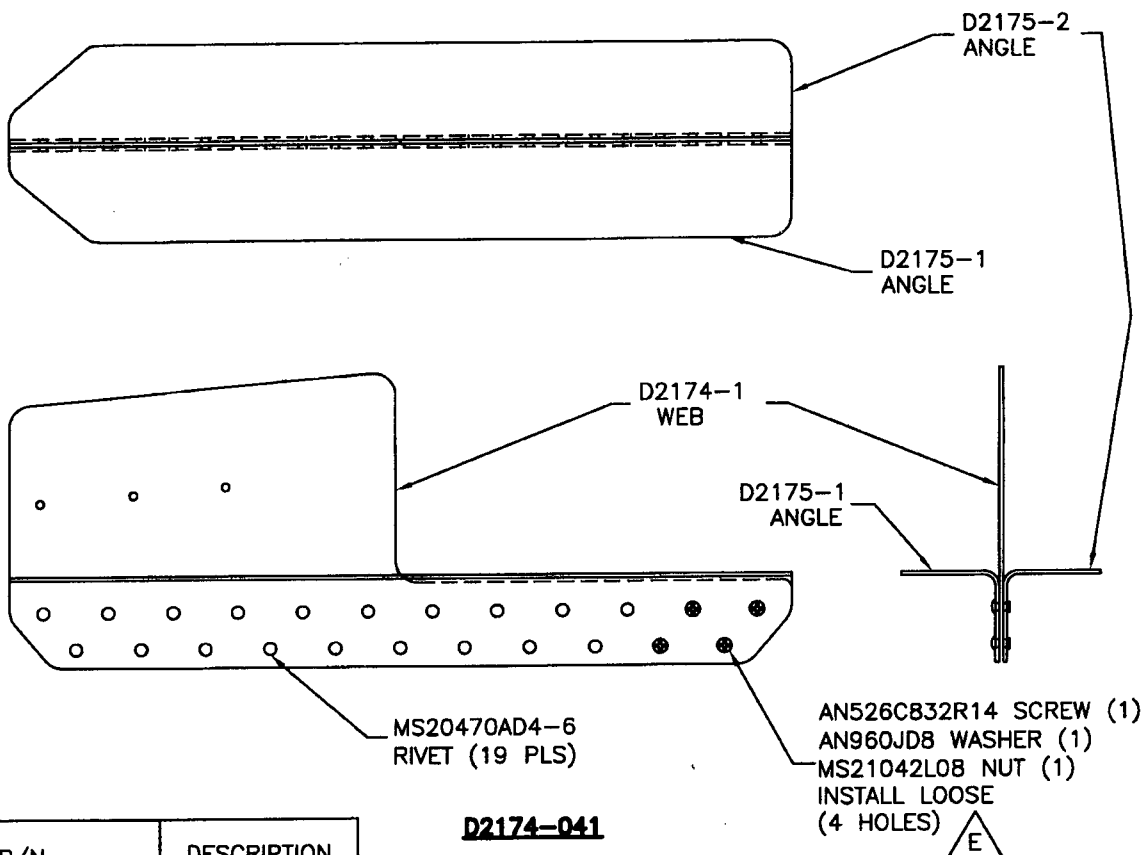
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED CE	DRAWING NO. D2174
DATE 06.09.25	TITLE WEB ASSEMBLY	REV. E
A	95.10.25	NEW ISSUE
B	96.01.18	RE-DRAWN
C	00.09.11	UPDATE FINISH SPEC.
D	04.06.03	RE-DESIGN
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE



D2174-041

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO COMMENT
WHEN USED
WORK CENTER

NO - 794684.2.5
12/01/96

RELEASED
06-10-13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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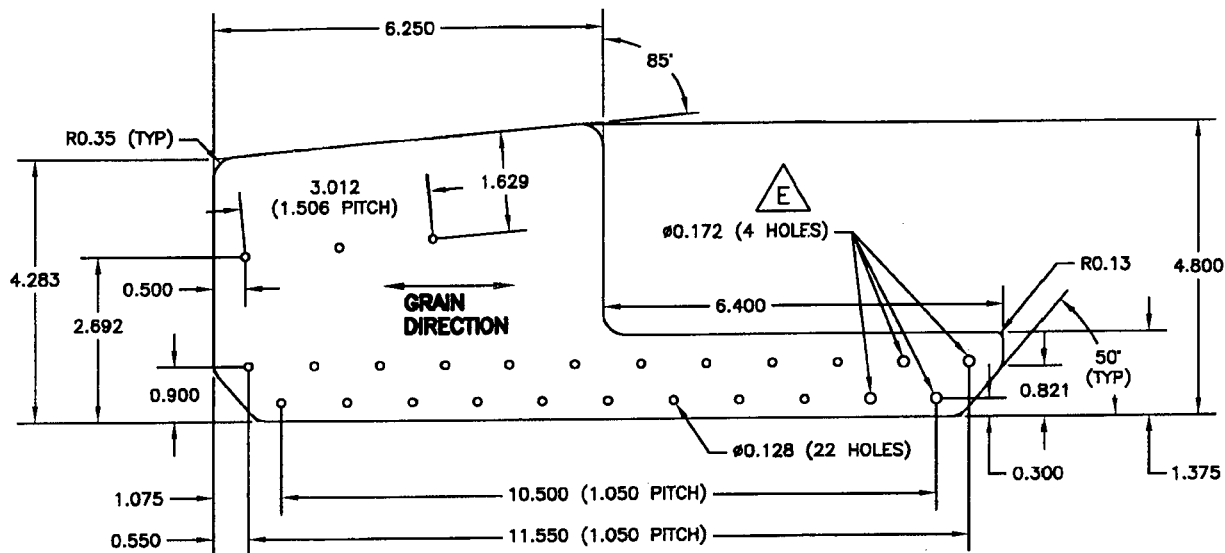
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794600

DESIGN RF	DRAWN BY CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2174	REV. E SHEET 2 OF 2
DATE 06.09.25	TITLE WEB	SCALE 1:3	

RELEASED
JUL 10 1963



D2174-1

NOTES:

- NOTES:**
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) ALL DIMENSION ARE IN INCHES

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